

Date: Tuesday, 11/13/2007 1:24:16 PM
User: Kim Johnston

Process Sheet

Spel
SBS 07/11/20

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ACCESS PANEL ASSEMBLY
Job Number	: 35650-1		
Estimate Number	: 13009		
P.O. Number	:	Part Number	: D3245042
This Issue	: 11/13/2007 S.O. No. :	Drawing Number	: D3245 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 34552	Material	:
Written By	:	Due Date	: 11/28/2007
Checked & Approved By	: <i>John H. B. 11/13</i>	Qty:	6 Um: Each
Comment	: Est Rev:A New Issue 07-09-11 JLM Verified By:EC Est Rev:b ECN 1052 07-10-31 DD verified by:		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1 	
			
Comment: PACKAGING RESOURCE #1			
Pick Packing Kit			
2.0	D32452	Panel 	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)			
Panel			
Batch: <i>B 35651</i> <i>SB 08/01/15</i>			
3.0	D32455	Angle Plate 	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) <i>B 34607 x 3</i> <i>SB 07/12/19</i>			
Angle Plate			
Batch: <i>B 35047 x 6 B 35667 x 3</i> <i>SB 07/12/19</i> <i>(20)</i>			
4.0	235018C3Y	RIGID RECEPTACLE 	
			
Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s) <i>m 105729 x 16</i> <i>SB 07/12/19</i> <i>MF 08-01-15</i>			
RIGID RECEPTACLE			
Batch: <i>m 106037 x 3</i> <i>m 106037</i> <i>SB 07/12/19</i> <i>(20)</i>			
5.0	MS20427M33	Rivet 	
			
Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s) <i>M 101840 x 21 M 105728 x 15</i> <i>SB 07/12/19</i> <i>(20)</i>			
Rivet			
Batch: <i>M 105940 x 96</i> <i>All Samp New</i> <i>SB 07/12/19</i> <i>(20)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:24:17 PM
User: Kim Johnston

Process Sheet

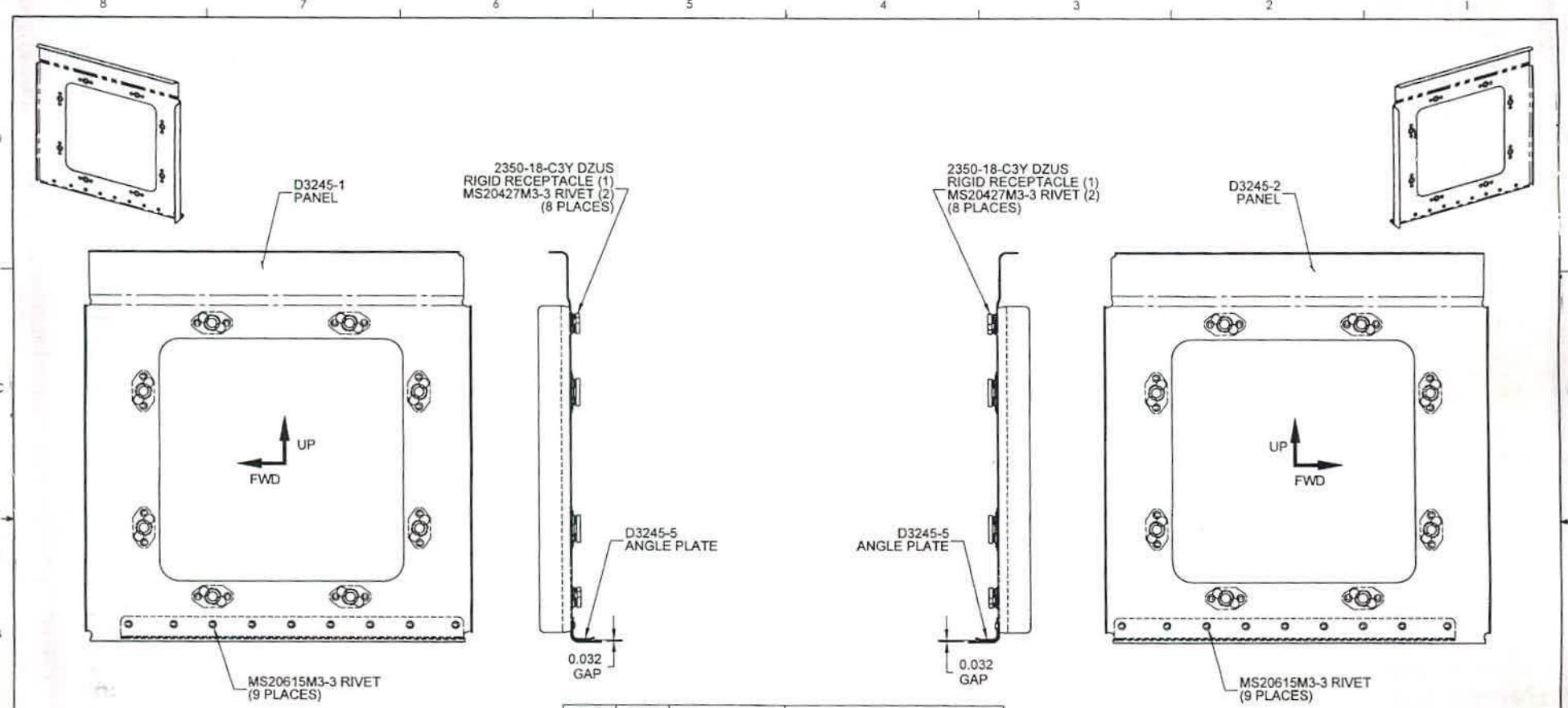
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ACCESS PANEL ASSEMBLY
Job Number: 35650		Part Number: D3245042
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	MS20615M33 3M3 	Rivet <i>All same batch</i>
Comment: Qty.: 9.0000 Each(s)/Unit Total : 54.0000 Each(s) Rivet		M 106277 18/01/19
7.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245		MF 08-01-15 MF 08-01-09 MF 07-12-20
8.0	QC5 	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		5 08/01/15
9.0	PACKAGING 1 	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify with Dart P# and B# using fine point permanent ink marker and Stock Location: 183		8/1/15 30
10.0	QC21 	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		10 08-01-21
Job Completion 		U 08-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3245-041 ACCESS PANEL ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1	D3245-1	PANEL	
1	D3245-2	PANEL	
1	D3245-5	ANGLE PLATE	
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

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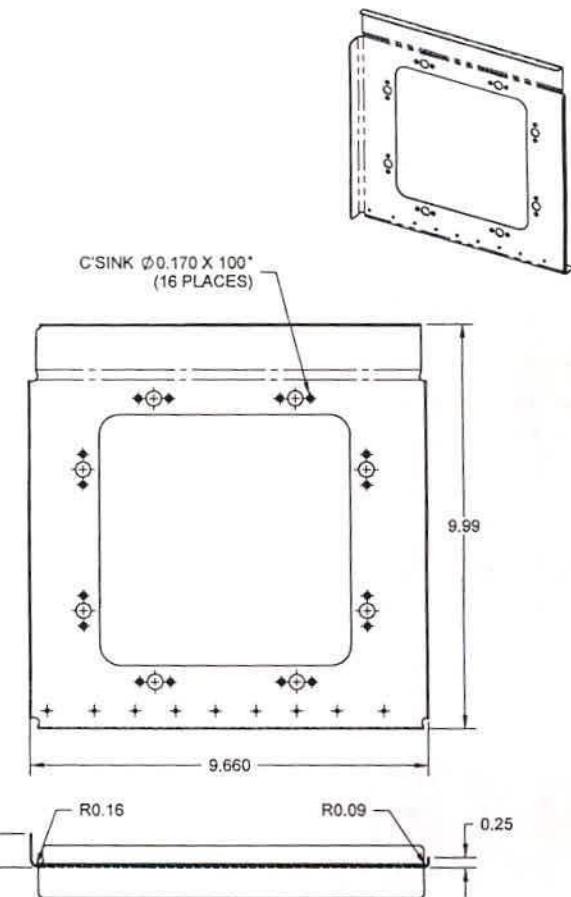
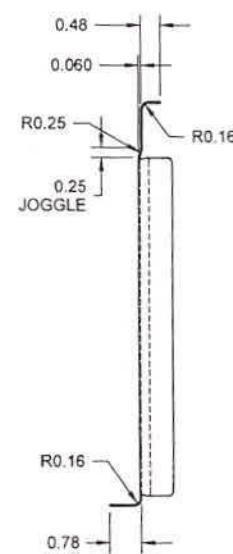
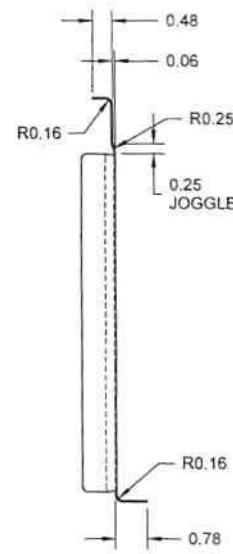
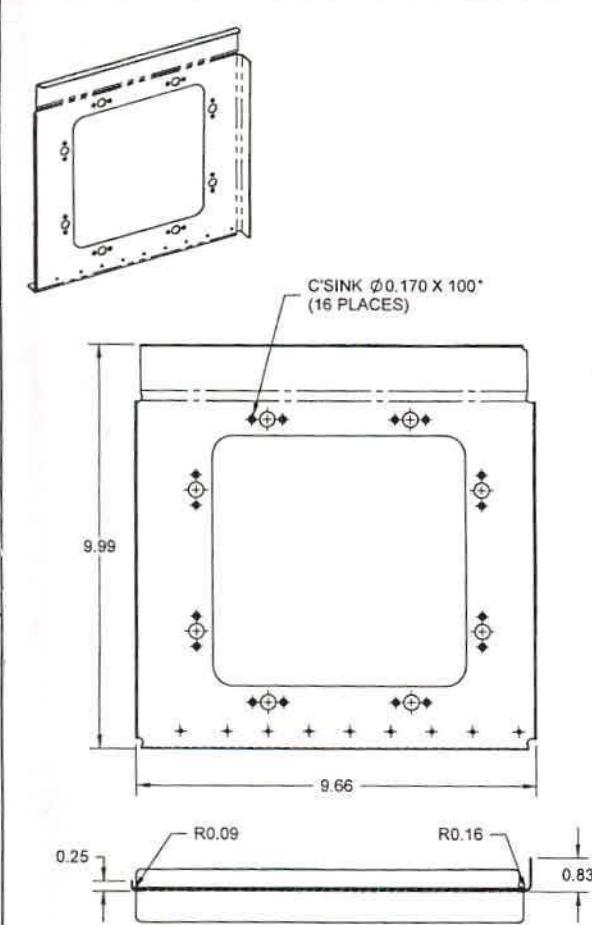
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.83 lbs

D3245-042 ACCESS PANEL ASSEMBLY

B	REMOVE ⌀0.204 HOLES FROM D3245-1-1F. REMOVE MS21060-13K NUTPLATES & DURABLA BLACK GASKETS FROM D3245-041/042; HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PF</i>	DART AEROSPACE LTD	
DRAWN	<i>PF</i>	HAWKSLEY, ONTARIO, CANADA	
CHECKED	<i>PF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>PF</i>	D3245	SHEET 1 OF 7
APPROVED	<i>PF</i>	TITLE	SCALE
DE APPR.	<i>PF</i>	ACCESS PANEL ASSEMBLY	12.5
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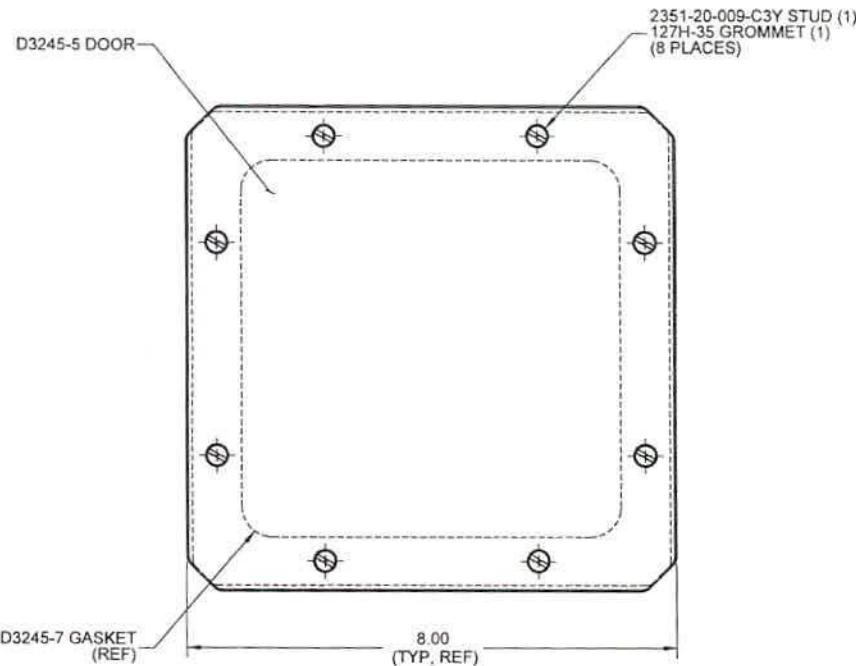
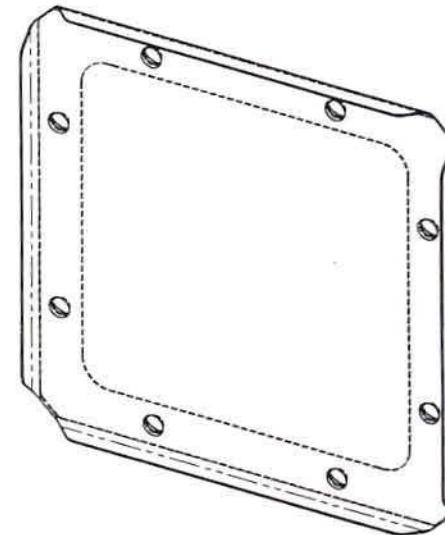
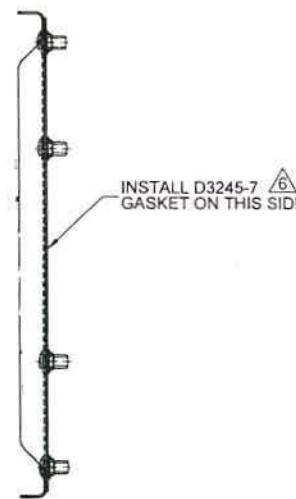
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NOTES:
1) MATERIAL: MAKE FROM D3245-1F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.70 lbs

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DATE	07.10.02	TITLE SCALE ACCESS PANEL ASSEMBLY

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8 7 6 5 4 3 2 1

D3245-043 DOOR ASSEMBLY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

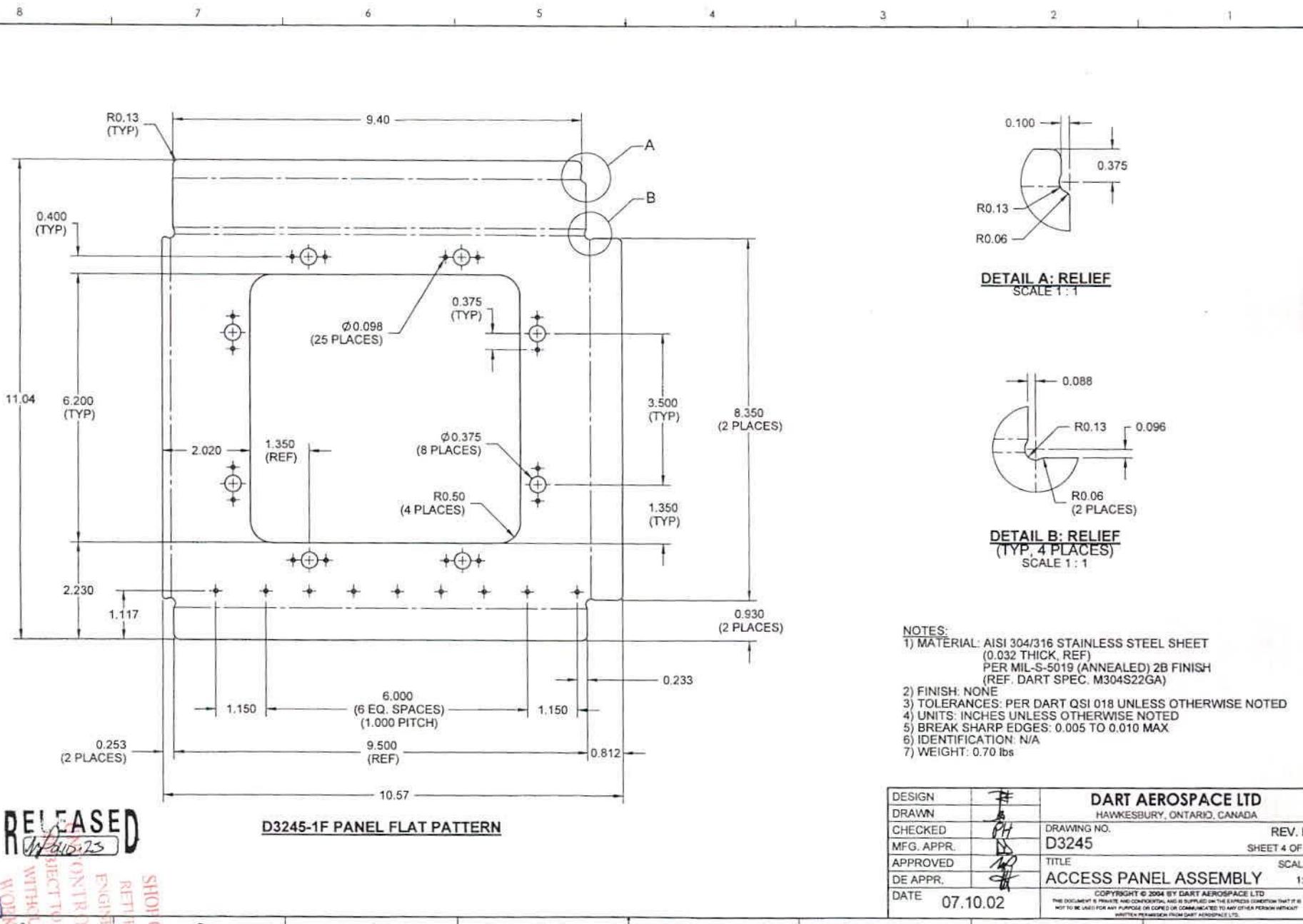
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

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MFG. APPR.	<i>DS</i>	SHEET 3 OF 7
APPROVED	<i>MP</i>	TITLE ACCESS PANEL ASSEMBLY
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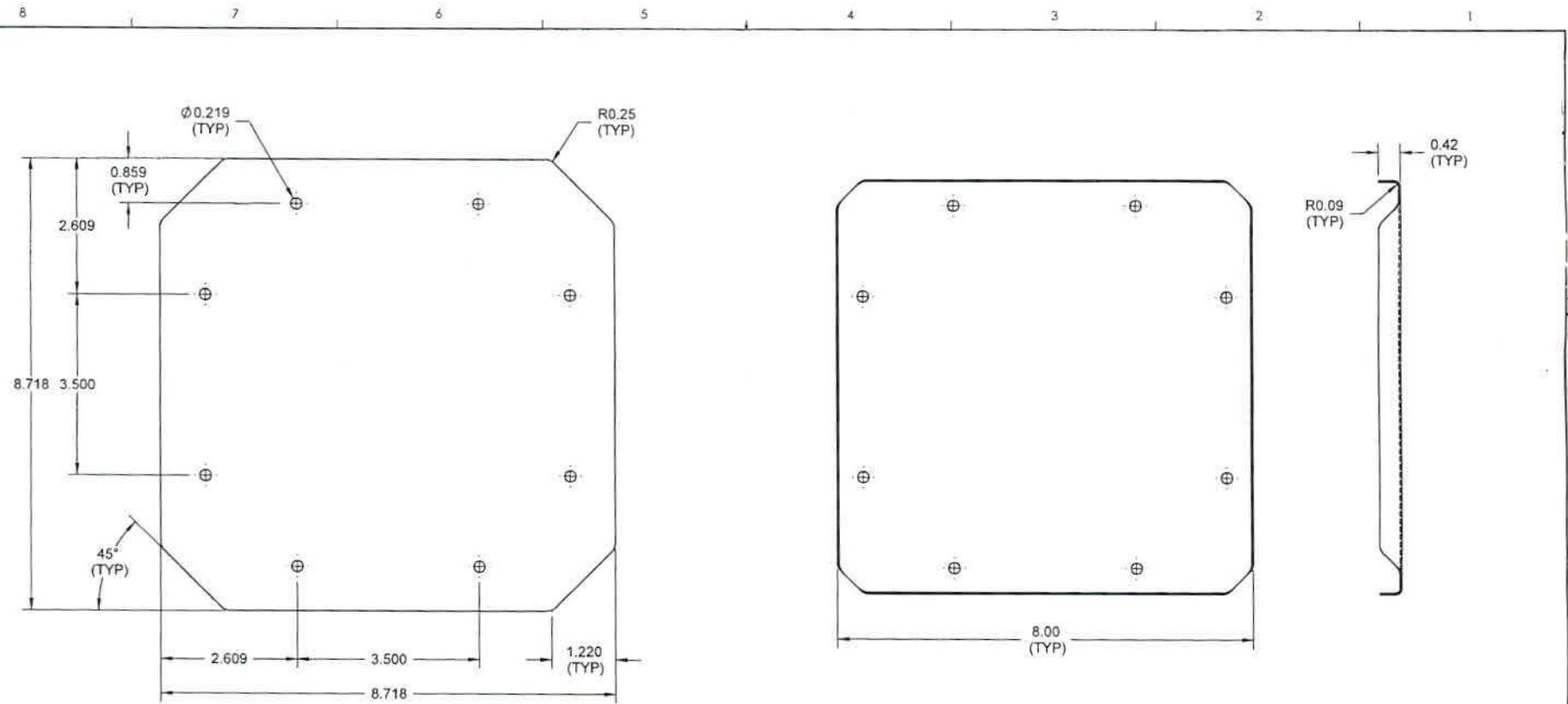


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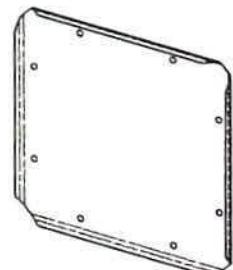
D3245-3F DOOR FLAT PATTERN

D3245-3 DOOR BENDING DETAIL

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07-10-02

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

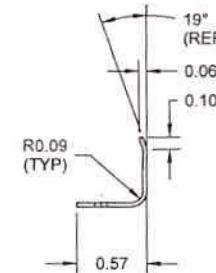
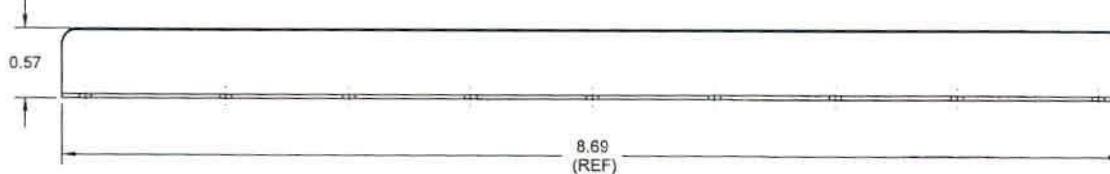
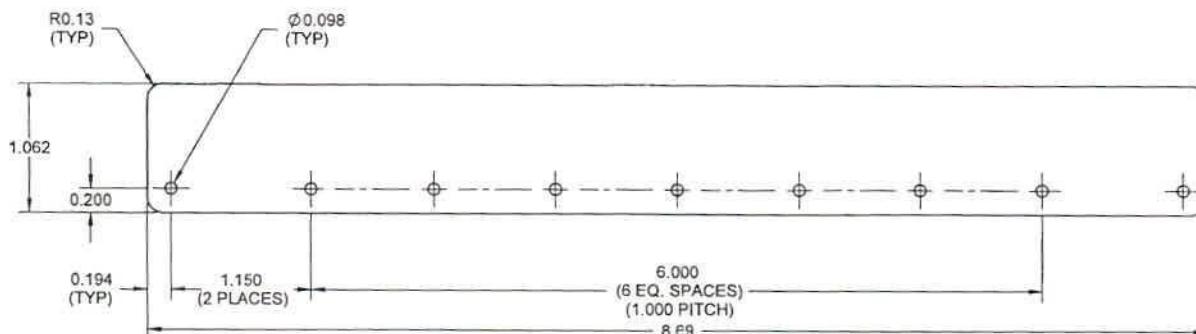
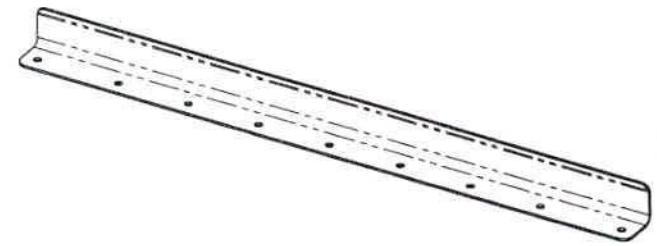


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DATE	07.10.02	TITLE
		SCALE
		1:2
		ACCESS PANEL ASSEMBLY

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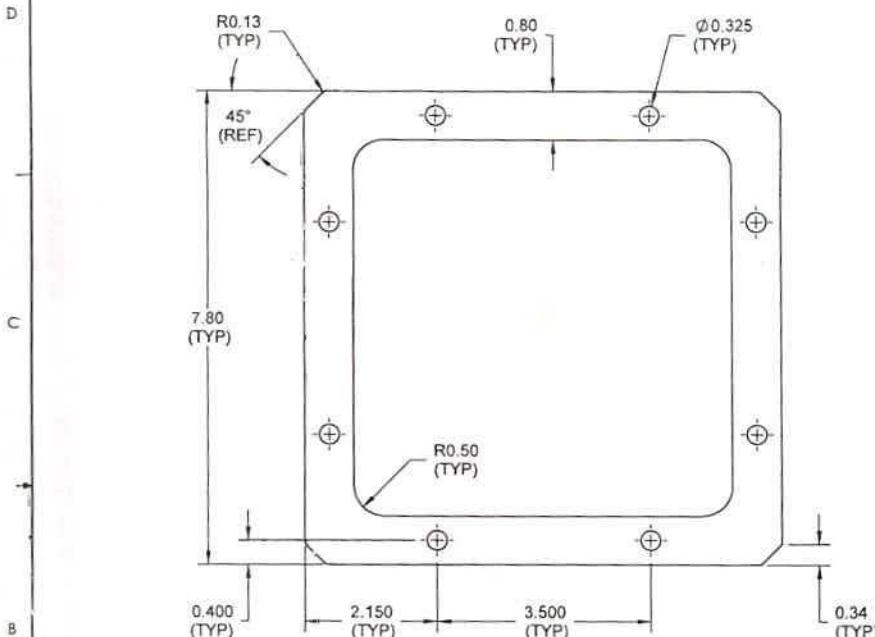
NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
 PER MIL-S-5019 (ANNEALED) 2B FINISH
 (REF. DART SPEC. M304S22GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.08 lbs

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8 7 6 5 4 3 2 1

D3245-7 GASKETD3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

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- NOTES:
 1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK
 (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

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DATE	07.10.02	SCALE 12

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